

# Work Order ID 59175

May 27, 2010 12:49:02 PM



Page 1

Item ID: D3463-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment Assembly

Start Date: 5/27/10 Start Qty: 2.00



Cust Item ID:

Required Date: 5/27/10 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: [Signature] Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3463	Rev B
-------	-------

155

0.00



Small Fab

Small Fab

Memo

PULL FROM STOCK:  
2 X D3463-042 B56602

RE-IDENTIFY AS D3463-041  
MADE ON W/O 56602, BUT ARE LH'S

0.00

SB 10/05/27

②

170

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

10-05-27

u 10-05-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3463-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 59175		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-05-27	155	D3463-042's found in sth, but are really -041's  R.C. Lack of Attention,	<i>[Signature]</i>	create w/o to re-identify as LH  <del>raise NCR</del>	10-05-27			

NOTE: Date & initial all entries

# Picklist Print

May 27, 2010 12:49:01 PM

Page 1

Work Order ID: 59175



Parent Item: D3463-041



Parent Item Name: Step Weldment Assembly

Start Date: 5/27/10

Required Date: 5/27/10

Comments: IPP REV. A 05.11.18 new issue EC IPP revB: replace pressure  
with wing walk DD 10.01.28 verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3463-042		Manufactured	No				Each	0.0000		2			



Step Weldment Assembly



B56602 ②

# Work Order ID 56602

Tuesday, March 02, 2010 8:28:59 AM

Page 1

Item ID: D3463-042

Accept

Revision ID:

Item Name: Step Weldment Assembly

Start Date: 3/3/2010 Start Qty: 2.00

Required Date: 3/17/2010 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: *mf*

Date: *10-3-2*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3463

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld assembly as per dwg D3463 using DT8875

*12 10-4-17 X2*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

*(2) PD 10.04.20*

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*8/10/04/21*

*(X2)*

# Work Order ID 56602

Tuesday, March 02, 2010 8:28:59 AM



Page 2

Item ID: D3463-042

Accept



Setup Start



Revision ID:

Item Name: Step Weldment Assembly

Stop



Start Date: 3/3/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 3/17/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M114207	0.00	=> M 10/04/26			X2	4		
Powdercoat Powder Coating	Memo Mask areas indicated on dwg D3463 (holes, threads) START TIME: 10:00 AM OVEN TEMPERATURE: 900°F FINISH TIME: 10:30 AM	0.00							
140 	Wing Walk as per dwg QSI005 4.4 Batch M113545	0.00							
HandFinish Hand Finishing	Memo	0.00							
150 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							

② 10-4-26

10-4-26 JF (2)

**Work Order ID 56602**

Tuesday, March 02, 2010 8:28:59 AM

Page 3

Item ID: D3463-042

Accept

Revision ID:

Item Name: Step Weldment Assembly

Start Date: 3/3/2010 Start Qty: 2.00

Required Date: 3/17/2010 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Packaging Packaging	Identify as per dwg & Stock Location: <u>494</u>  Memo	0.00  0.00							<u>10-4-27</u> <u>JS</u> <u>EC</u>
170 QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<u>10/04/27</u> <u>JS</u> <u>PS 10-4-27</u> <u>(2)</u>

# Picklist Print

Tuesday, March 02, 2010 8:28:58 AM

Page 1

Work Order ID: 56602

Parent Item: D3463-042

Parent Item Name: Step Weldment Assembly


Comments: IPP REV. A 05.11.18 new issue EC

Start Date: 3/3/2010

Required Date: 3/17/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
238-806  SS DOWEL PIN 1" LONG		Purchased	No			100	Each	48.0000	4.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	48	
105037	3	
111088	41	
19080	4	

EL 10-4-19

45

D3453-3

  
Clevis

Manufactured No

100 Each 16.0000 2.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	16	
52983	2	
56051	6	
56095	8	

EL 10-4-19

2

D3453-5

  
Plug

Manufactured No

100 Each 21.0000 2.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	21	
46265	11	
52985	10	

EL 10-4-19

2

# Picklist Print

Page 2

Tuesday, March 02, 2010 8:28:58 AM

Work Order ID: 56602



Parent Item: D3463-042



Parent Item Name: Step Weldment Assembly


Start Date: 3/3/2010

Required Date: 3/17/2010

Comments: IPP REV. A 05.11.18 new issue EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3463-1  Arm		Manufactured	No			100	Each	18.0000	2.0000			



EL 10-4-19

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

55816

18

2

D3463-3

Manufactured No

100

Each

52.0000

2.0000



EL 10-4-19

Step

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

52

46149

5

46269

47

2

Tuesday, March 02, 2010 8:28:58 AM

Shop Packet Print

Page 2



# Picklist Print

Page 3

Tuesday, March 02, 2010 8:28:58 AM

Work Order ID: 56602

Parent Item: D3463-042

Parent Item Name: Step Weldment Assembly


Comments: IPP REV. A 05.11.18 new issue EC

Start Date: 3/3/2010

Required Date: 3/17/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3463-5  End Cap		Manufactured	No			100	Each	33.0000	4.0000			

EL 10-4-19

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

1

1

55815

1

Main Warehouse

WA

32

3

56049

32

D3463-7

Manufactured No

100

Each

0.0000

2.0000



Drag Arm

EL 10-4-19

B55814 x 1  
B56295 x 1

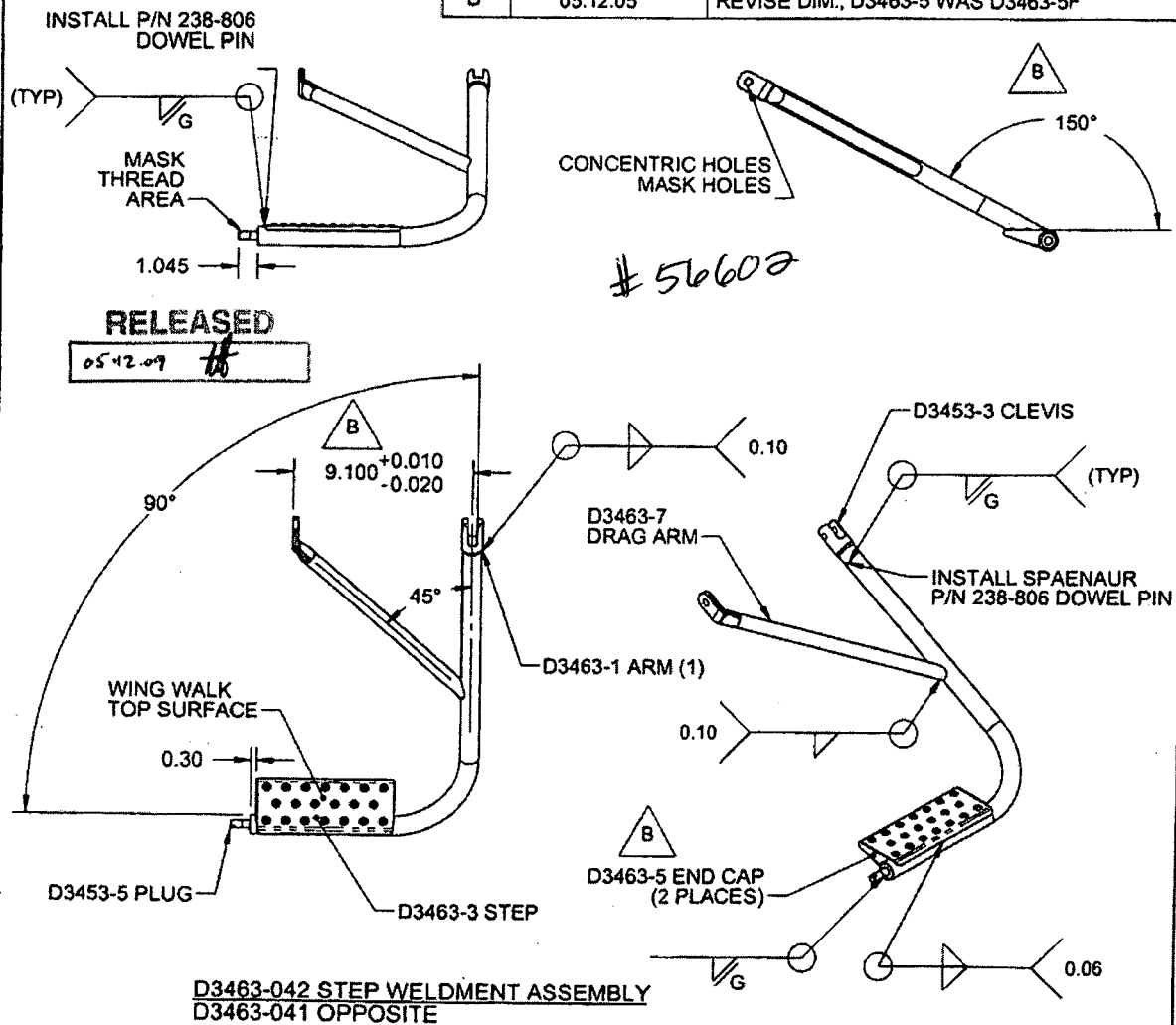
Tuesday, March 02, 2010 8:28:58 AM

Shop Packet Print

Page 3

**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3463</b>	REV. B SHEET 1 OF 4
DATE <b>05.12.05</b>		TITLE <b>STEP WELDMENT</b>	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

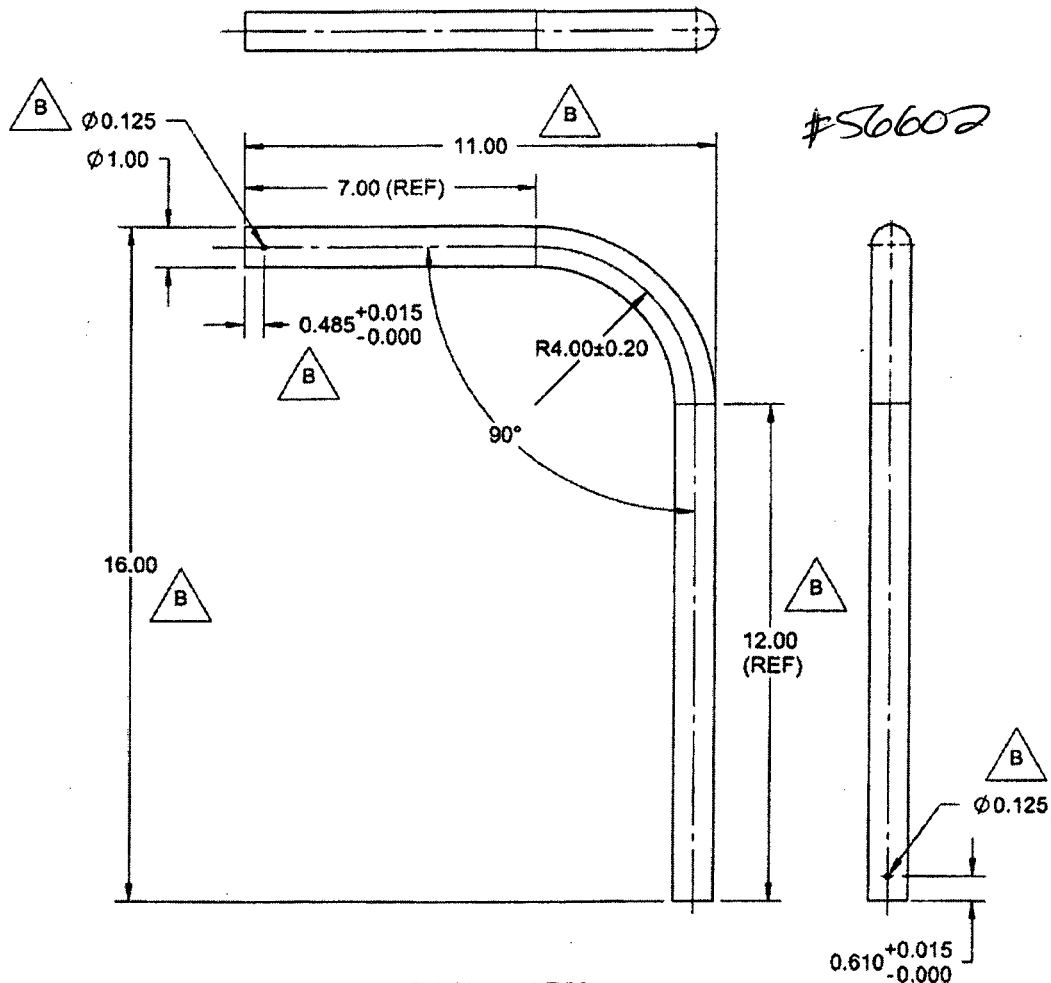
COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.09 *[Signature]***D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

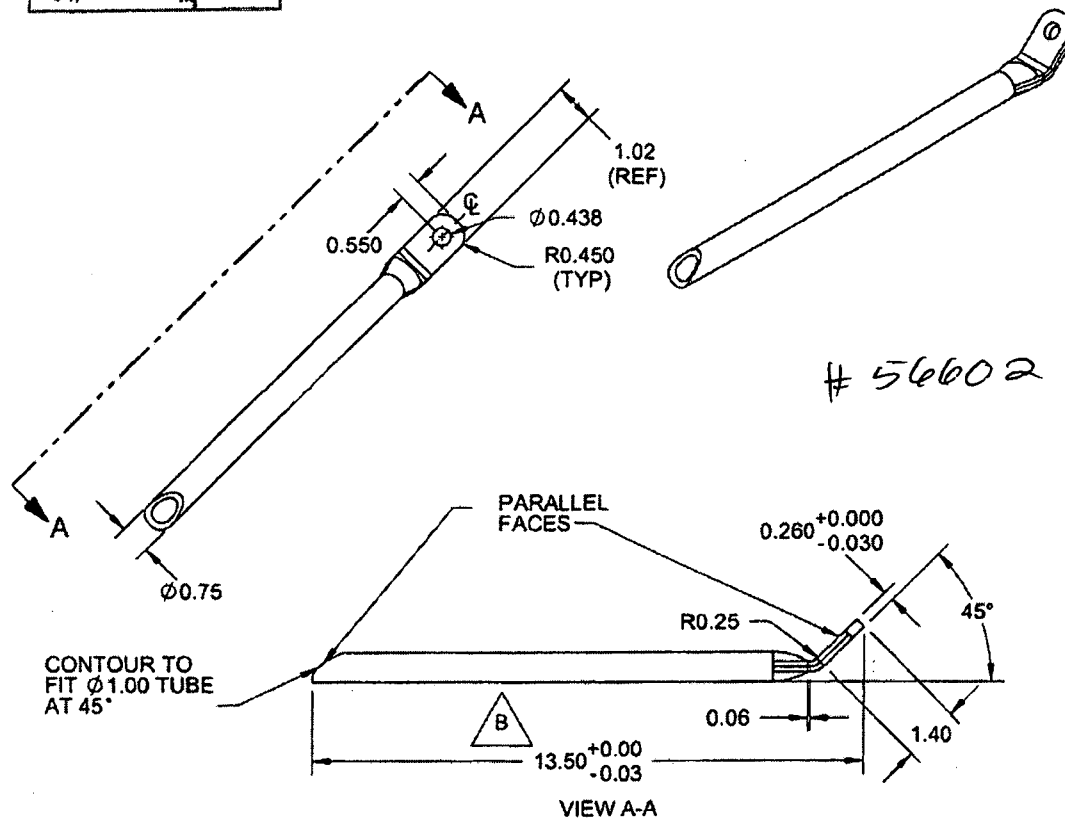
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

**RELEASED**

05.12.09 #

**D3463-7 DRAG ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

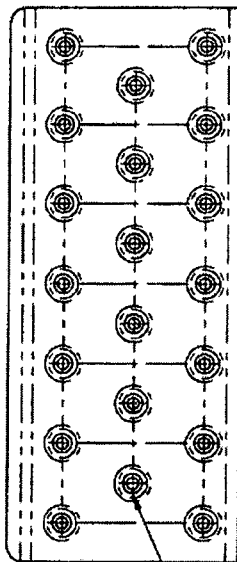
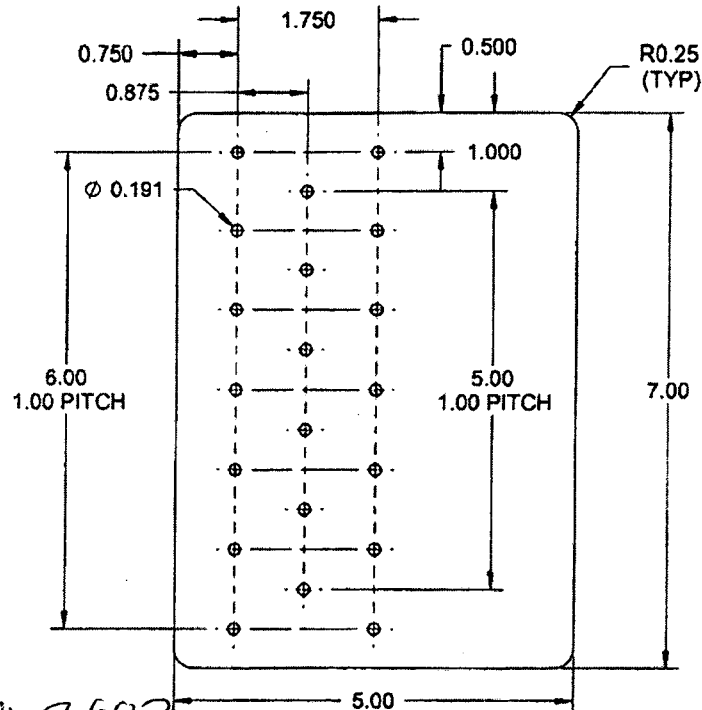
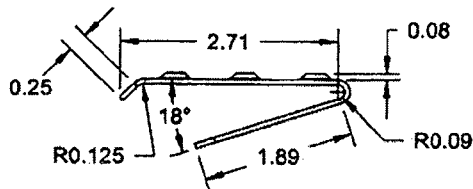
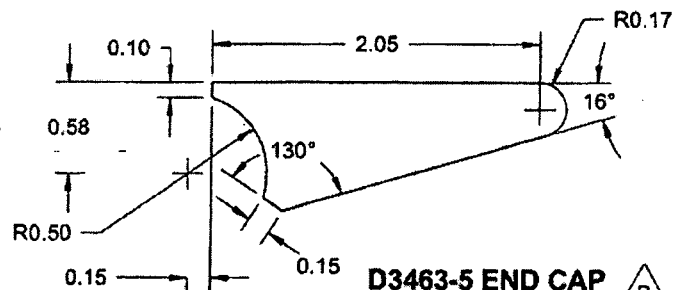
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3463</b>	REV. B SHEET 4 OF 4
DATE <b>05.12.05</b>	TITLE <b>STEP WELDMENT</b>		SCALE 1:2

**RELEASED**

05.12.05 #

FORM USING  
D3463-3T1**D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**  
SCALE 1:1**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.